

Work Order ID 59090

Wednesday, May 26, 2010 10:35:28 AM



Page 1

Item ID: D3913-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 5/26/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-5-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D3913
2- remove identification marks and deburr

SAD
10-08-13

(2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. W. 10/8/16

(2)

120

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD
10-08-13

(2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 59090

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Page 2

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Accept



Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/16
MF
10-8/16

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 26, 2010 10:35:32 AM

Page 1

Work Order ID: 59090

Parent Item: D3913-7

Parent Item Name: Rib

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/26/2010

Required Date: 5/31/2010

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.500W.049 | | Purchased | No | | | 100 | f | 64.4350 | 1.594 | 3.355789 | | | |



Square Tubing



SAD 10-08-12

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT | 13.6499 | |
| 114426 | 13.6499 | |
| MAT018 | 4.4738 | |
| 114004 | 0.5 | |
| 114161 | 3.9738 | |
| WA | 46.3113 | |
| 114724 | 46.3113 | |

M115034 → 3.3558

| W/O: | | WORK ORDER CHANGES | | | | | |
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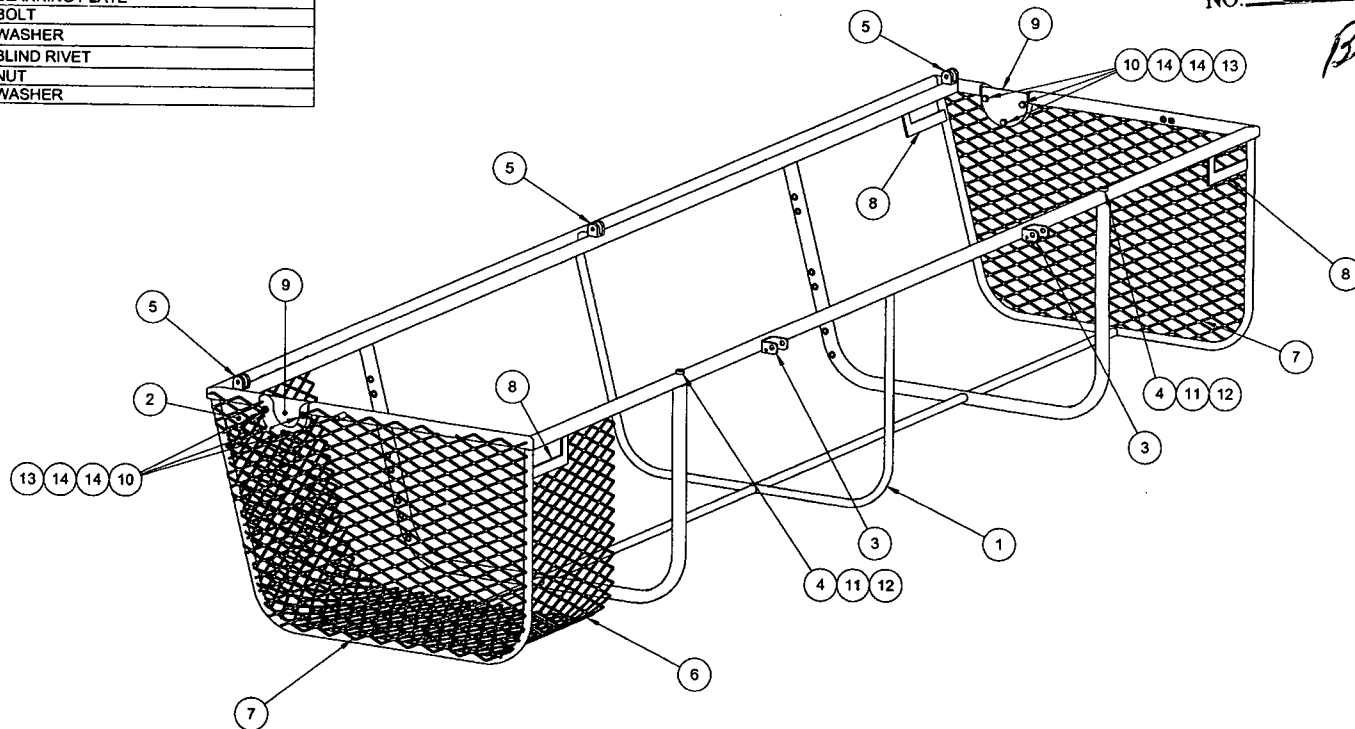
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NOTE: Date & initial all entries

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|---------------|---------------------------------|
| | X | D3913-041 | LONG BASKET BASE ASSY (350) |
| 1 | 1 | D3913-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 2 | 1 | D3913-15 | WIDE HANDLE PLATE |
| 3 | 2 | D2581 | MOUNTING BRACKET |
| 4 | 2 | D2931 | BUMPER |
| 5 | 3 | D4016-1 | HINGE HALF, BASE |
| 6 | 1 | D4020-1 | MESH (350 BASKET LONG BASE) |
| 7 | 2 | D4020-11 | END MESH, BASKET |
| 8 | 3 | D4021-1 | HANDLE PLATE |
| 9 | 2 | D4021-5 | BLANKING PLATE |
| 10 | 6 | AN3-10A | BOLT |
| 11 | 2 | AN960JD8 | WASHER |
| 12 | 2 | MS20600AD4W3 | BLIND RIVET |
| 13 | 6 | MS21042L3 | NUT |
| 14 | 12 | NAS1149F0332P | WASHER |



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY,
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59290
BS10-5-26

RELEASED
2010-03-22
W

| A | NEW ISSUE | JPH | 10.03.16 |
|--|-------------|-----|----------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | | |
| DRAWN | JPH | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.03.16 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 TITLE LONG BASKET BASE ASSY (350) SCALE NTS REV. A SHEET 1 OF 6 | | | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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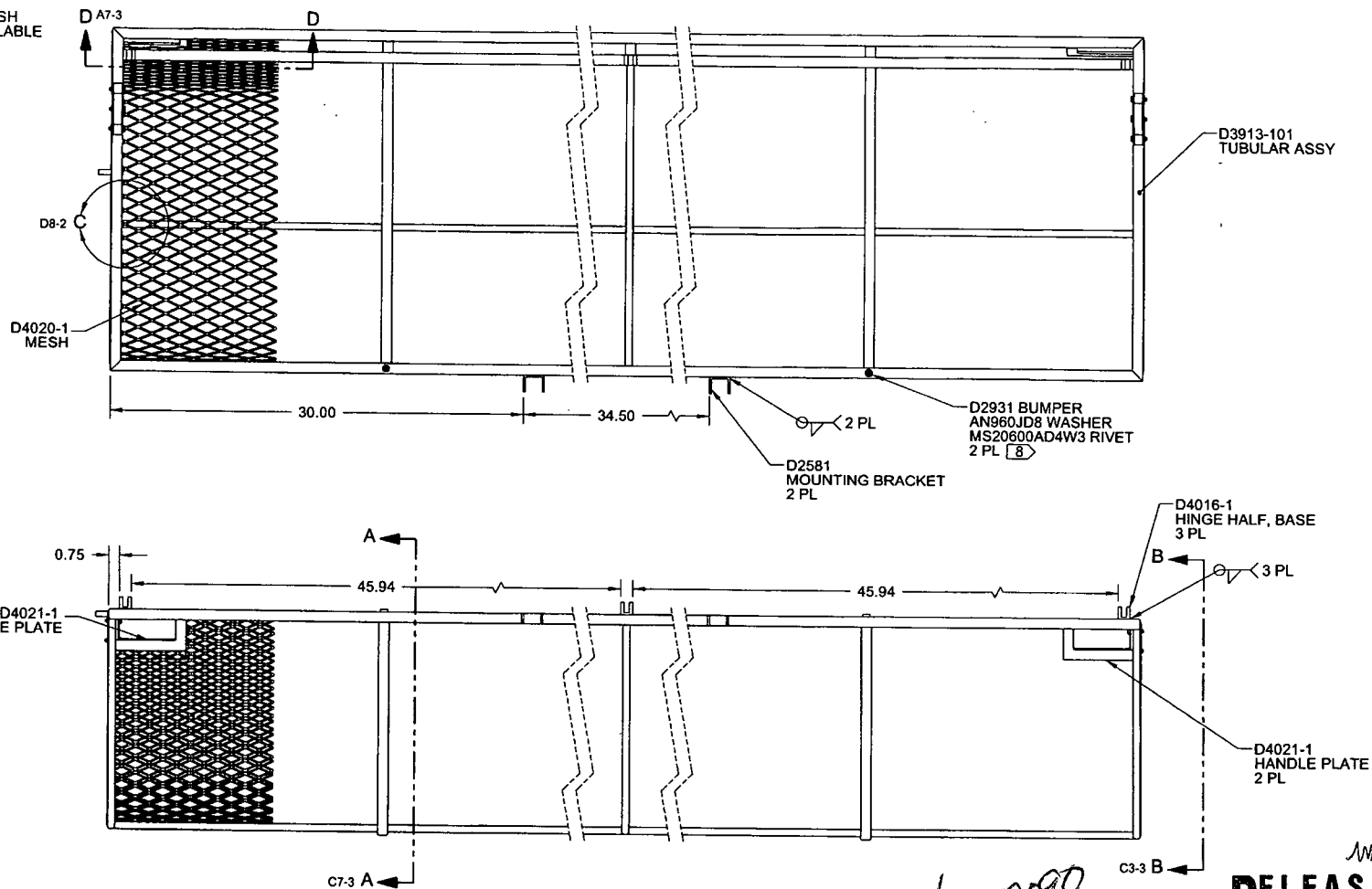
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NOTE: Date & initial all entries

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JFH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3913 | SHEET 2 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY (350) | NTS |
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2010-05-27

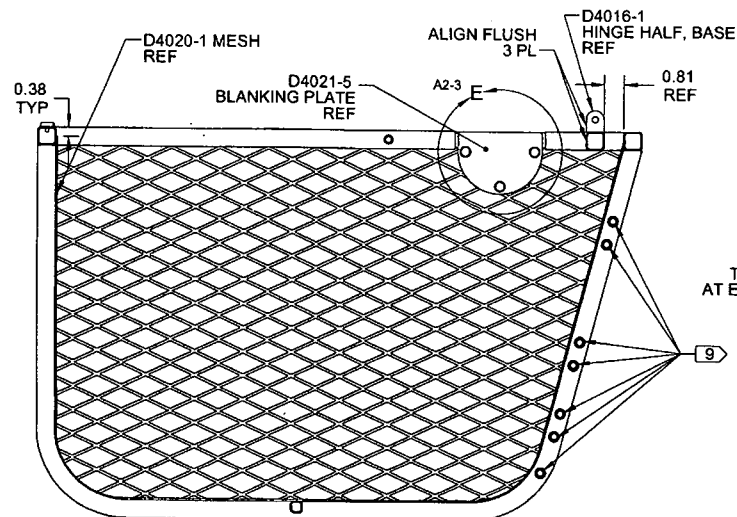
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

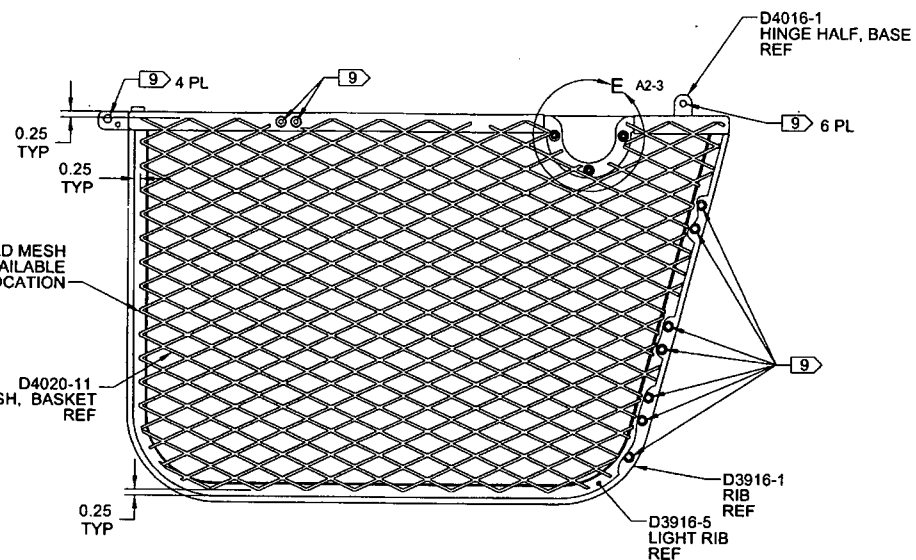
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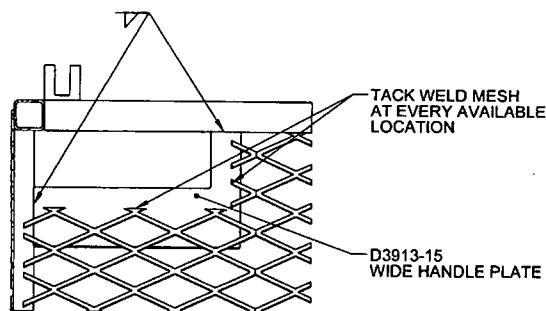
NOTE: Date & initial all entries



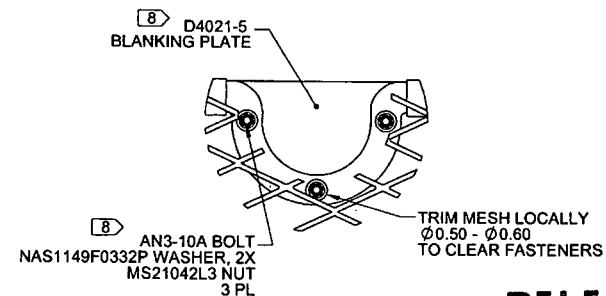
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JRH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3913 | SHEET 3 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY (350) | NTS |
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2010-03-22

w/o 39090

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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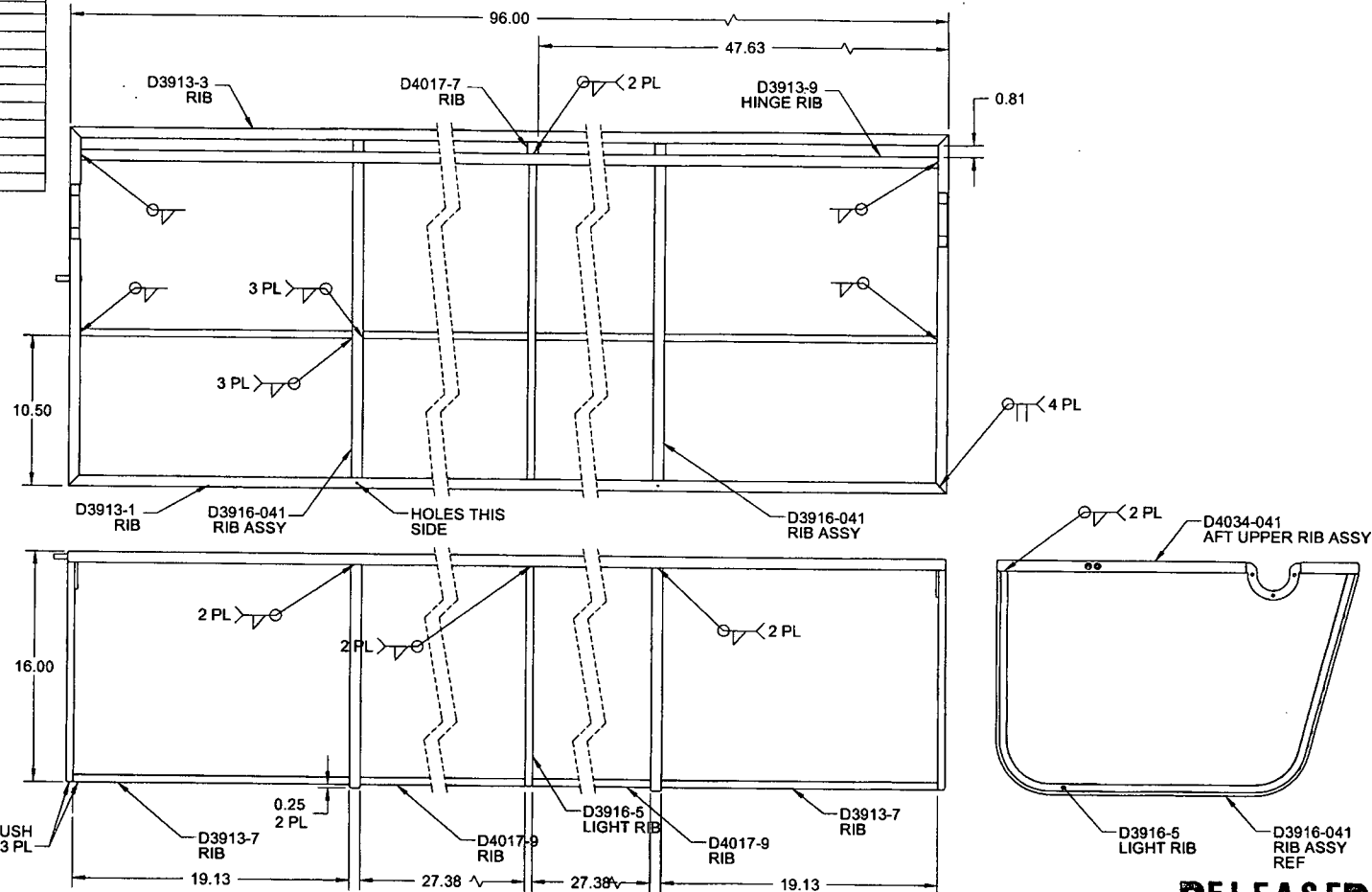
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|--------------------------------|
| | X | D3913-101 | TUBULAR ASSY (350 LONG BASKET) |
| 1 | 1 | D3913-1 | RIB |
| 2 | 1 | D3913-3 | RIB |
| 3 | 2 | D3913-7 | RIB |
| 4 | 1 | D3913-9 | HINGE RIB |
| 5 | 3 | D3916-5 | LIGHT RIB |
| 6 | 2 | D3916-041 | RIB ASSY |
| 7 | 1 | D4017-7 | RIB |
| 8 | 2 | D4017-9 | RIB |
| 9 | 1 | D4034-041 | AFT UPPER RIB ASSY |
| 10 | 1 | D4034-043 | FWD UPPER RIB ASSY |



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JRH | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3913 | SHEET 4 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY (350) NTS | |
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2010-03-22

WLO 39090

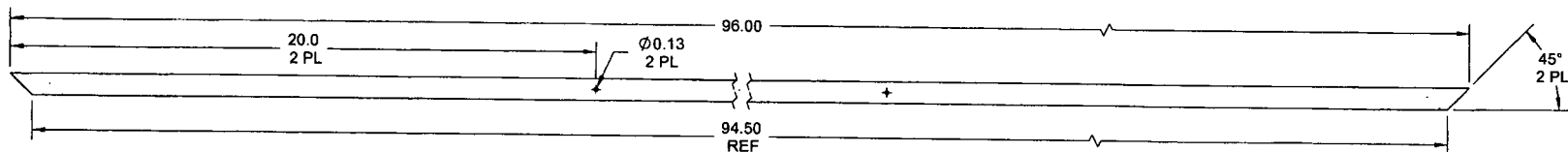
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

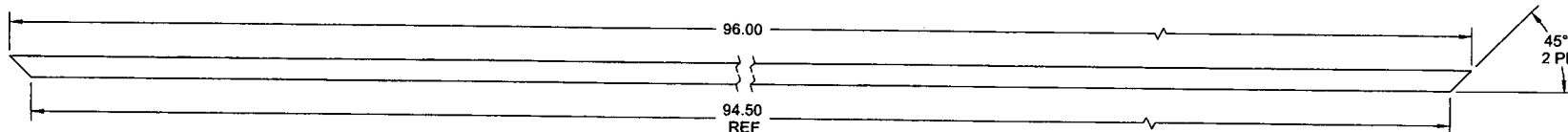
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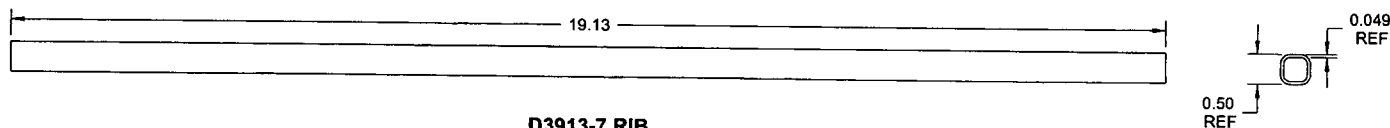
NOTE: Date & initial all entries



D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2010-03-22

| | | | |
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| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JS | DRAWING NO. | REV. A |
| MFG. APPR. | JS | D3913 | SHEET 5 OF 6 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | LONG BASKET BASE ASSY (350) NTS | |
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w/o 59090

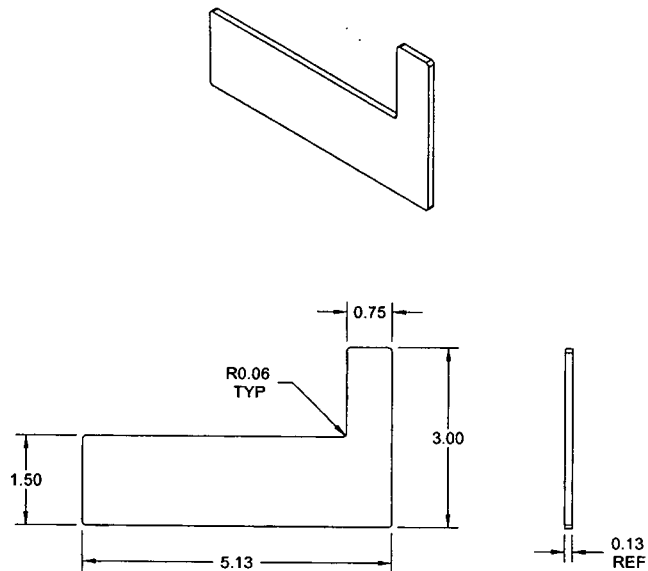
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NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

wb 39090

RELEASED
2010-03-22
md

| | | | |
|------------|--------------------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JFH | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3913 | SHEET 6 OF 6 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | LONG BASKET BASE ASSY (350) NTS | |
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NOTE: Date & initial all entries